

Date: Wednesday, 07/01/2009 1:36:48 PM
User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ARM
Job Number :	44474		
Estimate Number :	12884		
P.O. Number :		Part Number :	D3560044
This Issue :	07/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3560 REV D
First Issue :	1/1	Project Number :	N/A
Previous Run :	41288	Drawing Revision :	D
Written By :	<i>[Signature]</i>	Material :	
Checked & Approved By :	<i>[Signature]</i>	Due Date :	23/01/2009
Comment :	Type : MACHINED PARTS Qty: 8 Um: Each Est Rev:A New Issue 07.05.24 EC Est Rev B ECN 987 07.10.09 EC verified by DD Est Rev:C ECN1048 07-12-18 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00
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Comment: Qty.: 1.3598 f(s)/Unit Total: 10.8780 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: 110550

[Signature] 07/01/20 (5)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
Cut blanks 15.500" long

[Signature] 07/01/20 (8)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: *A* & Dwg D3560 Rev: *D*

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

[Signature] 07/01/20 (8)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

[Signature] 07/01/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 07/01/2009 1:36:48 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 44474

Part Number: D3560044

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 09/01/26

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
PLATE 344066

09.01.30

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad)
- 2- set up bracket and arm on jig
- 3- preheat bracket and arm with torch
- 4- clean before welding with brush
- 5- set up machine to 135 amps
- 6- weld across bottom and top ends
- 7- reheat with torch (65 deg C)
- 8- on one side weld from bottom to top half way
- 9- same for other side (half way)
- 10- from half way point weld the rest of the first side (ease off pedal near end)
- 11- same for remaining side (ease off pedal near end)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

re-work
09.01.30 6

09.01.30 (8)

9.0

QC9

VISUAL WELDING INSPECTION



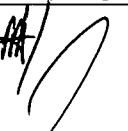
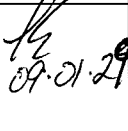




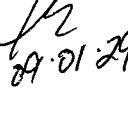

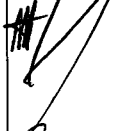

Comment: VISUAL WELDING INSPECTION

09/01/30

09/01/30 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3560-044 PAR #: N/A Fault Category: Prod/Ins. Large NCR: (Yes) No DQA: D Date: 09/02/06
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: D Date: 09/02/07

NCR: <u>44474</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-01-29	4.0	welds cracked on part while welding on 2 parts. R.C. Process.		scrap parts - Remove the tiny crack on part 1 by zip cutting it out, and re-weld affected part per QS1004	 09-01-29	 09-01-30	 09-01-30	 09-01-30
				Part #2: Remove the D3592-1 plate, and grind the welds on the arm flush. Replace D3592-1 plate; re-weld <u>to M108031</u> A/R rod	 09-01-29	 09-01-30	 09-01-30	 09-01-30

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 44474

Part Number: D3560044

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(8)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 09/02/02

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-02 (8)

12.0	D2808	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spacer

batch: 037113

09/02/02

13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

09/02/02

14.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

09-02-02 (8)

(PTU)

15.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAN 09-02-02 (8)

16.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/02/02


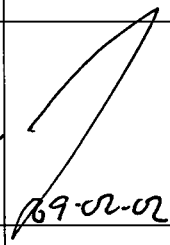
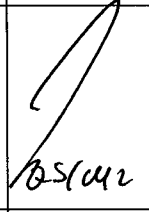

Job Completion



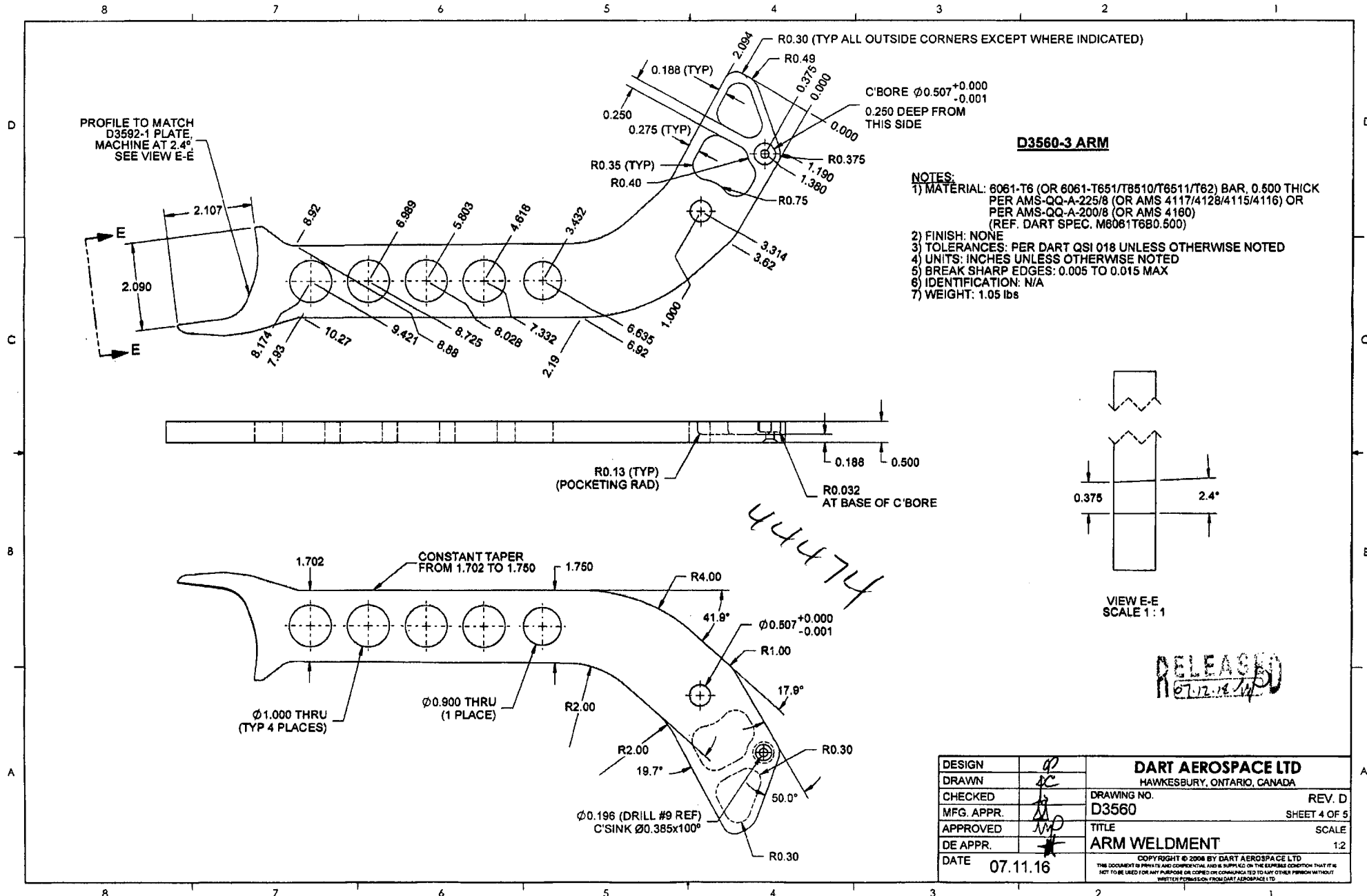
MF 09-02-03

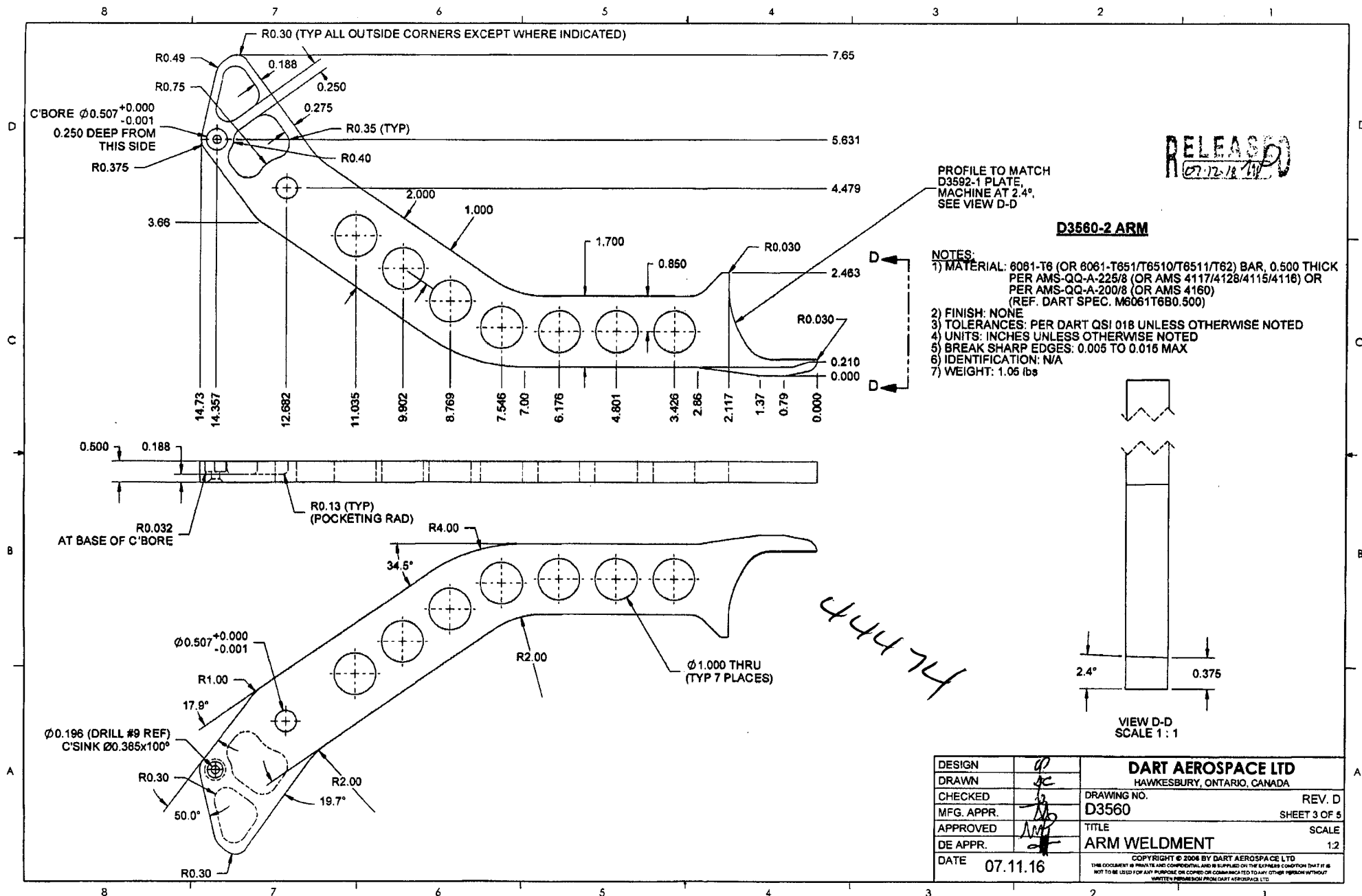
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

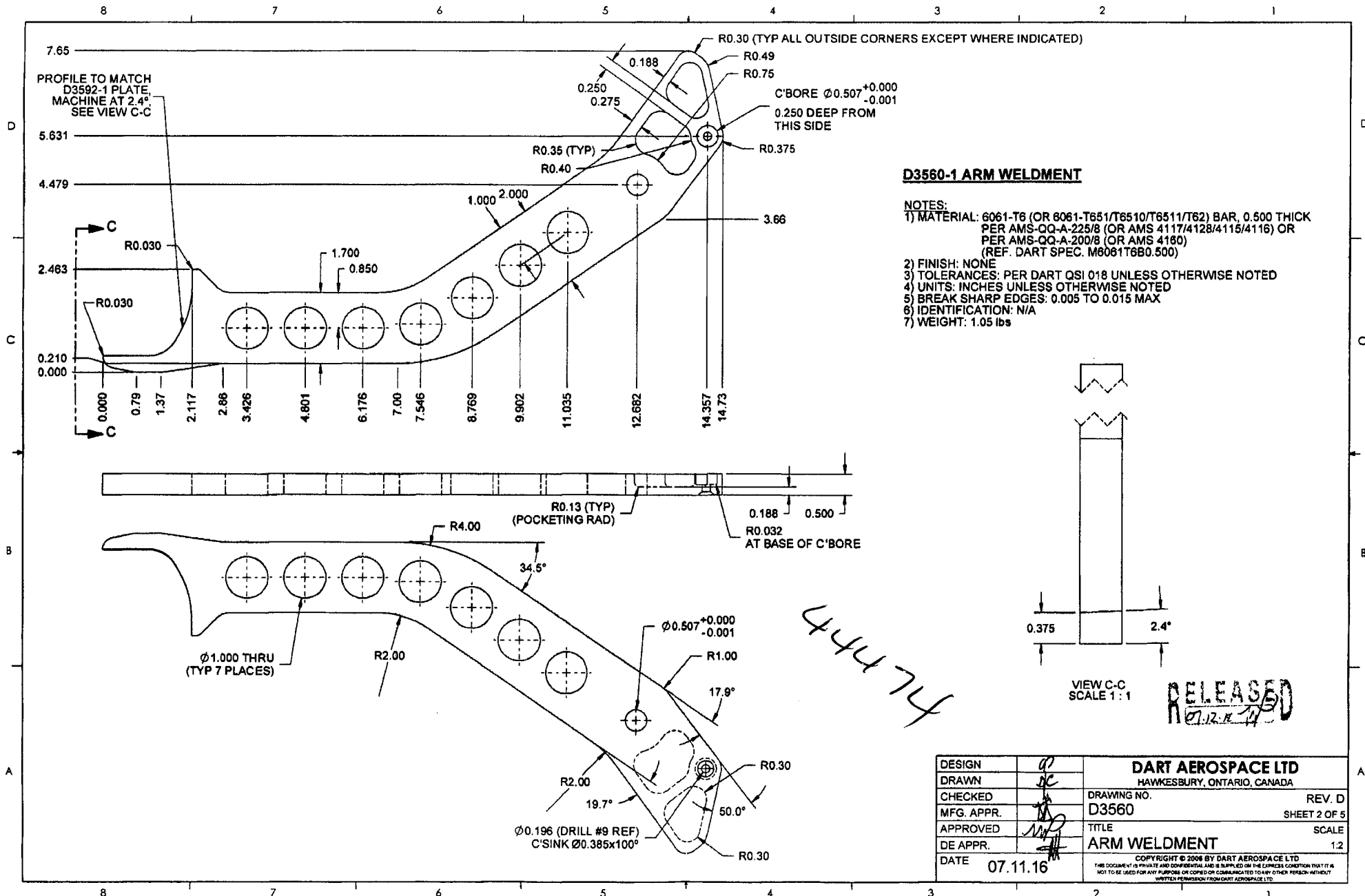
Part No: D3560-044 PAR #: N/A Fault Category: Roll/Pins Assy mod^{Small} NCR: Yes No DQA: D Date: 05/02/06
 Resolution: Accepted ~~fewer than 15~~ Disposition: USE AS IS QA: N/C Closed: D Date: 08/02/07

NCR: <u>44474</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-02-02	130	1 part, the C' bore $\varnothing 0.507$ + 0.0" - 0.001" has a diameter of 0.514". R.C. Chips in the bore oversized the hole.		Proceed, and will press fit the 2808 into the arm at the ass'y stage when all is powdercoated. This will work as was done before in the past, * Part is tagged as missing D2808	SB 09/02/02			

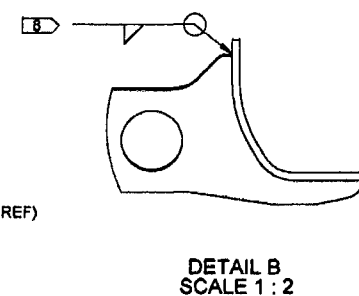
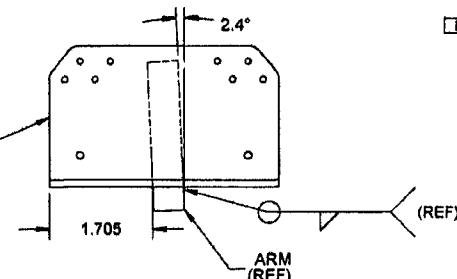
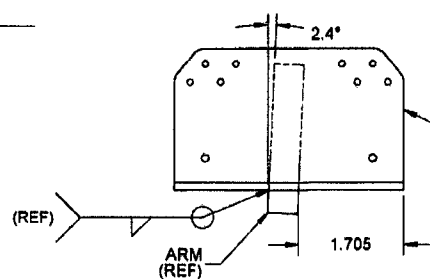
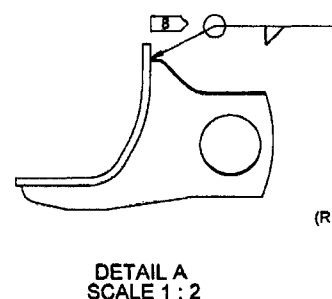
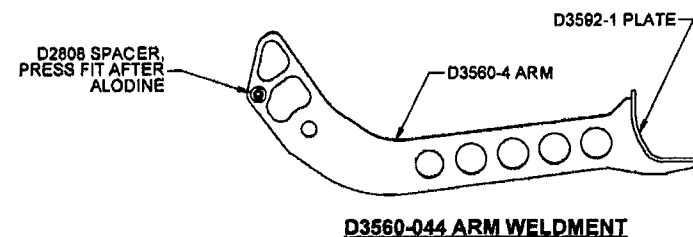
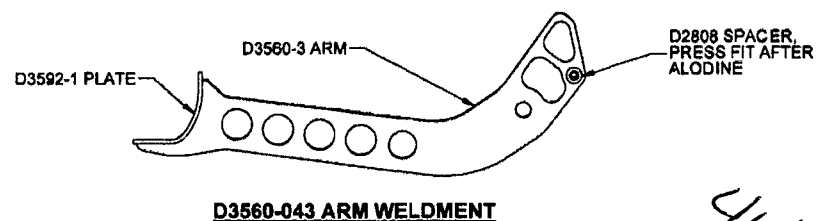
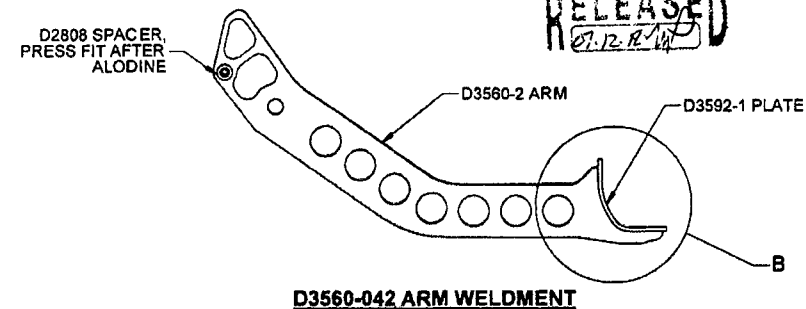
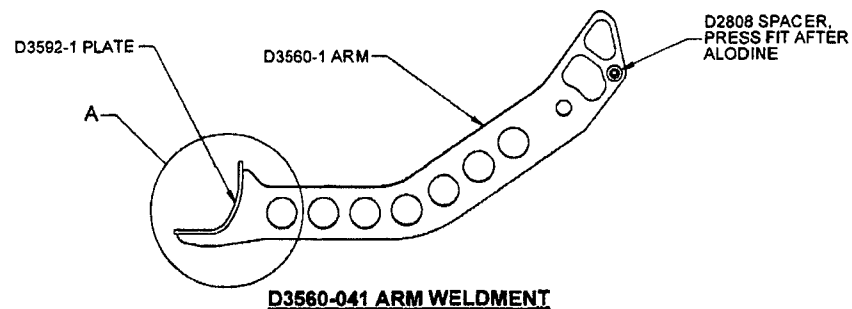
NOTE: Date & initial all entries







RELEASED
07.12.16



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.10
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560** REV. D
SHEET 1 OF 5

TITLE **ARM WELDMENT** SCALE 1:4

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